

Date: Thursday, 3/2/2006 3:07:36 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MOUNTING CHANNEL  
 Job Number : 26030  
 Estimate Number : 10605  
 P.O. Number : N/A Part Number : D2585  
 This Issue : 3/2/2006 S.O. No. : N/A Drawing Number : D2585 REV B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : B  
 Previous Run : 25328 Material : N/A  
 Written By : SEE COMMENT BELOW Due Date : 3/23/2006 Qty: 100 Um: Each  
 Checked & Approved By : 06.03.02  
 Comment : Est. D 04.02.16 Reformat; Add Receiving Step KJ/RF

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 705

Email or ship DXF file to vendor

Laser Cut D2585 as per Dwg D2585

Material release note required

2.0 D2585F Latch Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)  
 Latch Clamp

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material release note is attached

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per dwg D2585

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1




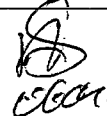

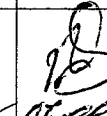
Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/04/19							

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DD Date: 26/04/21  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/04/19	6	1 piece out of Tolerance		Scrap & destroy	SB 06/04/19	 06/04/19	 06/04/19	 06/04/19

NOTE: Date & initial all entries

Date: Thursday, 3/2/2006 3:07:36 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING CHANNEL

Job Number: 26030

Part Number: D2585

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2585

SD

06/04/19

103

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Joe H. S

102  
PTO

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5751

06/4/19 102

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/04/21

(102)

Job Completion


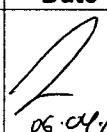
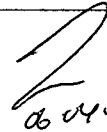




U 06-04-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/04/21  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

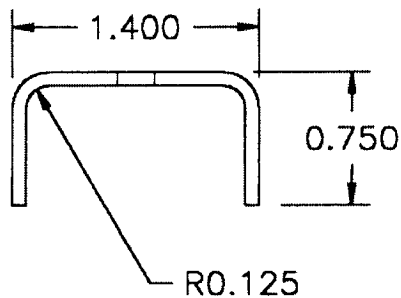
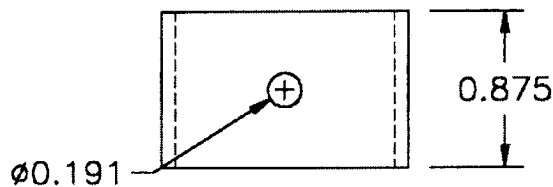
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-04-19	7	Found Insert with the hole sized wt, and badly damaged due to laser cut.		Scrap: des tray	 06-04-19	 06-04-19	 06-04-19	 06-04-19

NOTE: Date & initial all entries

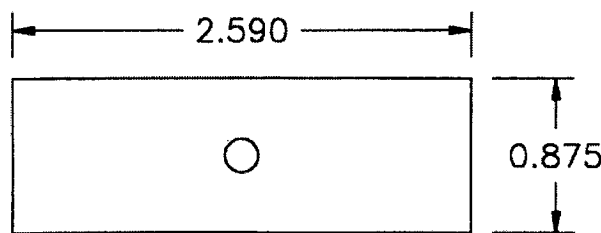


DESIGN BW	DRAWN BY MS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	DRAWING NO. D2585	REV. B SHEET 1 OF 1
DATE 96:07:11		TITLE MOUNTING CHANNEL	SCALE 1:1
B	97:03:14	ADD FLAT PATTERN	

RELEASED  
97/03/14 DS



FLAT PATTERN



MATERIAL: 304/316 SS, 14 GAUGE (0.078)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26030

Certificate 185045 02

Mail To:

ALASKAN COPPER & BRASS CANADA, INC.  
P.O. BOX 3546  
SEATTLE, WA 98124-3546

Ship To:

ALASKAN COPPER & BRASS CANADA, INC.  
225 NORTH ROAD AVENUE  
COQUITLAM, BC V3K3V7  
CANADA

Steel: 304

Finish: 2B

Your Order: V033868

NAS Order: AE 0249852 03

Corrosion: ASTM A262/01E; 180 Bend-OK

**PRODUCT DESCRIPTION:**

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.  
ASTMA240/01, A480/01, A666/00, ASMESA240/01, SA480/01, SA666/01  
QQS766D-A X MG PRM, AMS5513G X MRK&FIN, MIL5059D, AMD3, X CRWN MEAS

**REMARKS:**

Material free from mercury contamination. No weld repairs.

Product ID #	Coil #	Thickness	Width	Weight	-----Length-----	Mark	Pieces
A96138	* 0415N6 D	.0600	60.0000	4,940	120.0000	SHEET 8	42

**CHEMICAL ANALYSIS**

Heat	C	CR	CU	MN	MO	N	NI	P	S	SI
15N6	.059	18.401	.333	1.726	.366	.051	8.161	.029	< .001	.395

**MECHANICAL PROPERTIES**

Product ID #	Coil #	1 d o i c r	UTS KSI	.2% YS KSI	ELONG %-2"	Hard RB	Tail H Tail
A96138	0415N6	F T	96.06	49.79	48.68	85.00	88.00

MILL TEST

## MILL TEST CERTIFICATES

705

8705

YIH MAU CORP.

ORIGINAL

INVOICE NO. : F05M920

COMMODITY : PRIME COLD ROLLED STAINLESS STEEL SHEET

SPECIFICATION :

AISI 304

CUSTOMER :

OLBERT METAL SALES LIMITED

I. A. 高雄縣政府郵政特准掛號  
345, SHUN AN RD. LU CHU HSIANG  
KAOHSIUNG TAIWAN R.O.C.  
TEL: (07) 6972885 FAX: (07) 6978006  
CERTIFICATE NO. F05M920  
DATE OF ISSUE: 10/28/2005

TOTAL P. 04

SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test CL=50mm					Chemical Composition (%)								
		KGS	LBS			Y.S. (N/mm <sup>2</sup> )	T.S. (N/mm <sup>2</sup> )	E.L. (%)	HRB	HV	C x100	Si x100	Mn x100	P x1000	S x1000	Ni x100	Cr x100	N x100	
AISI 304/NO.4 (FILM ON MAIN SIDE WITH BACK-PASS)																			
24GA / 48" X 96"	1	1,367	3,014	N8E53719	48S71574-12	266	541	58	78	150	6	37	72	25	5	804	1800	3.7	
24GA / 48" X 120"	1	1,149	2,533	N8E53719	48S71574-13	266	541	58	78	150	6	37	72	25	5	804	1800	3.7	
24GA / 48" X 120"	1	946	2,086	N8E53719	48S71574-14	266	541	58	78	150	6	37	72	25	5	804	1800	3.7	
16GA / 36" X 96"	1	1,899	3,084	YU235551	48S12437-315	323	647	50	78	149	4.2	51	124	85	8	806	1817	2.7	
16GA / 36" X 120"	1	1,082	2,385	YU235551	48S12437-319	323	647	50	78	149	4.2	51	124	85	8	806	1817	2.7	
16GA / 36" X 120"	1	1,082	2,385	YU235551	48S12437-314	323	647	50	78	149	4.2	51	124	85	8	806	1817	2.7	
16GA / 60" X 96"	1	1,350	2,976	YU139585	48S14145A-21	302	654	58	78	144	4.7	49	125	82	5	805	1822	2.7	
16GA / 60" X 120"	1	1,082	2,385	YU235720	48S14157A-13	306	647	51	80	155	4.8	53	112	31	6	808	1832	2.7	
16GA / 60" X 120"	1	1,082	2,385	YU235720	48S14157A-14	306	647	51	80	155	4.8	53	112	31	6	808	1832	2.7	
14GA / 48" X 96"	1	1,894	3,078	YU235525	48S11699H-15	316	682	51	83	164	4.8	53	126	29	5	804	1808	2.3	
14GA / 48" X 120"	1	1,145	2,524	YU235525	48S11699H-16	316	682	51	83	164	4.8	53	126	29	5	804	1808	2.3	
14GA / 48" X 120"	1	1,145	2,524	YU235525	48S11699H-17	316	682	51	83	164	4.8	53	126	29	5	804	1808	2.3	
11GA / 48" X 120"	1	1,852	3,642	YU139676	48S14905A-112	306	656	51	84	166	6	48	111	29	11	805	1825	2.2	
11GA / 48" X 120"	1	1,852	3,642	YU139676	48S14905A-113	306	656	51	84	166	6	48	111	29	11	805	1825	2.2	
4																			
TOTAL:		14	17,527	38,638															
Remarks: NO MERCURY CONTAMINATION Bend test: good for all Heat NO.																			
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS																			

P50908PC001V

YIH MAU CORP.

Manager of Quality Assurance Section